Type 874-C
CABLE CONNECTOR*

Types 874-P and -PB
PANEL CONNECTORS*

(U. S. Patent No. 2,548,457)

Assembly of Type 874-C.

Remove cable jacket and insulation to expose braid and inner conductor to dimensions shown in Figure 1.

Slip on cord guard (874-71; see Figure 2) using talc if necessary, coupling nut (874-62), and ferrule (FEC-3). Insert inner transition piece (874-64) through the end of the outer transition piece (874-63), and slip inner transition piece over inner cable conductor until the end touches the cable insulation; then solder. Install snap ring (874-81) in groove nearest slot. (If the transition piece has two grooves, disregard groove nearest tapered end.) Slide outer transition piece onto cable, under braid and jacket as far as possible.

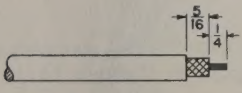

Figure 1.

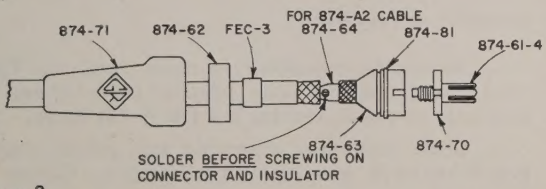

Figure 2.

Insert inner connector (Type 874-61-4) in insulator (874-70) and thread into inner transition piece, holding the hex-shaped part with wrench.[1, 2] CAUTION: Insulator will melt if inner connector and insulator are screwed on before the cable is soldered.

Slide outer transition piece (874-63) up to insulator (874-70). Align keyways. Slip outer connector (874-60-3) over insulator (874-70) and outer transition piece so that keys engage keyways. Thread up coupling nut (874-62) until it bottoms firmly.[3]

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*For use with General Radio Type 874-A2 Cable.

[1]The Type 874-TOK Tool Kit is recommended for assembly of all Type 874 Connectors. This kit consists of a Type 874-TO117 inner-connector wrench, a Type 874-TO115 outer-connector wrench, and a Type 874-TO116 coupling-nut wrench.

[2]To install inner connector and insulator in rigid line or inner transition piece using tools: insert inner connector into insulator and push assembly into the end of the inner-connector wrench, observing alignment of keys and keyways. Thread assembly into the rod or inner transition piece.

[3]Clamp coupling-nut wrench on ring coupling nut, push outer-connector wrench onto outer connector, and hold while tightening coupling nut.

Tighten and arrange braid over small end of outer transition piece. Cover with ferrule (FEC-3) and crimp in place. To crimp, use a Type 874-TO58 Crimping Tool or hold ferrule against a sturdy surface and pinch and push simultaneously with a pair of ordinary gas pliers as shown in Figure 3. The Crimping Tool is recommended for large-quantity operations or where the neatest crimp is desired. To use this tool, disengage the ratchet lock by squeezing the handles together, carefully position the ferrule in the largest die (0.375-inch), and squeeze the handles together until the ratchet lock releases.

Stretch rubber cord guard (874-71; see Figure 2) over coupling nut (874-62).

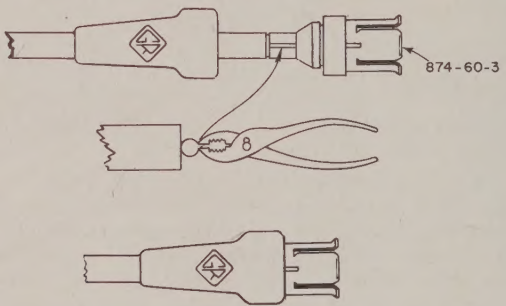


Figure 3.

Assembly of Type 874-P.

Assemble connector to cable same as Type 874-C but less rubber cord guard. Mount panel adaptor (874-65; see Figure 4) through 15/16-inch hole in panel, leaving nut (NUH-10) loose.

Slide connector assembly into panel adaptor until pierced key engages keyways in connector assembly. Clamp in place by tightening nut (NUH-10).

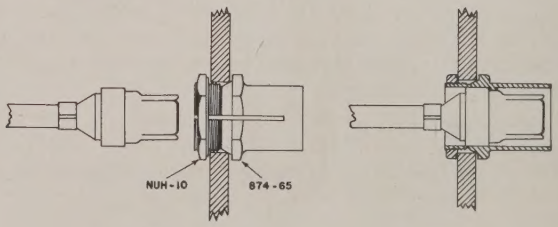


Figure 4.

Assembly of Type 874-PB.

Mount panel adaptor through 15/16-inch (panel in rear) or 7/8-inch (panel in front) hole as shown in Figure 5, using the four No. 4 screws provided. Remove retaining nut (874-620) and slide it back over cable. Then assemble connector to cable the same as Type 874-C but less rubber cord guard.

Slide connector assembly into the panel adaptor (874-650) as far as it will go. Take care that the connector is properly oriented so that the panel adaptor key engages the groove on the side of the cable connector. Tighten retaining nut.

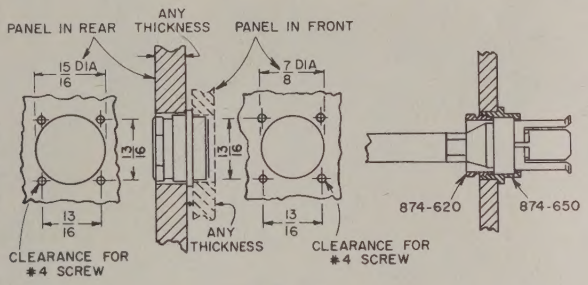
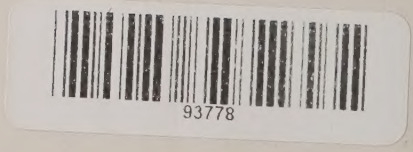


Figure 5.



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